



Dart Hawkesbury  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

5001796

D350-591-113  
Job Sheet 167073



Part No: D350-591-113

Job Qty: 4 ea

Part Name: Heli-Access Step, Short, High Gear



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/23/17

Job Tracking No:

Due Date: 10/27/17

Created By: Sian Willems

Type: Stock

Description:

Customer: Airbus Helicopters - Marignane (CEURO24)

Aéroport International De Marseille Cedex Marignane Marseille, , 13725 France ph:+33 4 42 85 85 85 fx:+33 4 42 85 83 00.

Ship Via:

fg039

### Bill of Materials

### Job Routing

| Op No          | Operation            | Qty              | Start Date | Due Date            | Standard        |                 | Workcenter/Supplier    |                         |
|----------------|----------------------|------------------|------------|---------------------|-----------------|-----------------|------------------------|-------------------------|
|                |                      |                  |            |                     | Setup hrs       | Run Hrs         | Workcenter / Supplier  | Lead Time               |
| 90             | Start up Operation   | 4 Ea             |            | 10/26/17            | 0.00            | 0.00            | Start Up Large Fab2    | CPC                     |
| 110            | Large Fab            | 4 pcs            |            | 10/26/17            | 0.00            | 4.13            | Large Fab 8            | CPC                     |
| <del>130</del> | <del>Large Fab</del> | <del>4 pcs</del> |            | <del>10/26/17</del> | <del>0.00</del> | <del>4.13</del> | <del>Large Fab 2</del> | <del>NOT REQUIRED</del> |
| 140            | QC                   | 4 pcs            |            | 10/26/17            | 0.00            | 0.00            | QC9                    | 17-11-09                |
| 150            | QC                   | 4 pcs            |            | 10/26/17            | 0.00            | 0.00            | QC5                    | 17-11-09                |
| 160            | HandFinish           | 4 pcs            |            | 10/26/17            | 0.00            | 0.89            | HandFinish1            | 17-11-10                |
| 170            | Large Fab            | 4 pcs            |            | 10/26/17            | 0.00            | 4.13            | Large Fab 2            | 17-11-10                |
| 180            | QC                   | 4 pcs            |            | 10/26/17            | 0.00            | 0.00            | QC10                   | 17-11-14                |
| 190            | QC                   | 4 pcs            |            | 10/26/17            | 0.00            | 0.00            | QC5                    | 17-11-14                |
| 200            | HandFinish           | 4 pcs            |            | 10/26/17            | 0.00            | 0.89            | HandFinish1            | 17-11-14                |
| 210            | Powdercoat           | 4 pcs            |            | 10/26/17            | 0.00            | 0.82            | Powdercoat1            | 17-11-15                |
| 220            | HandFinish           | 4 pcs            |            | 10/27/17            | 0.00            | 0.89            | HandFinish3            | 17-11-16                |
| 230            | QC                   | 4 pcs            |            | 10/27/17            | 0.00            | 0.00            | QC3                    |                         |
| 240            | Packaging            | 4 pcs            |            | 10/27/17            | 0.00            | 0.00            | Packaging1             | SMB                     |
| 250            | QC                   | 4 pcs            |            | 10/27/17            | 0.00            | 0.00            | QC4                    |                         |
| 255            | DC                   | 4 pcs            |            | 10/27/17            | 0.00            | 0.00            | DC                     |                         |
| 260            | Packaging            | 4 pcs            |            | 10/27/17            | 0.00            | 0.00            | Packaging3             | SMB                     |
| 270            | QC21-FG              | 4 Ea             |            | 10/27/17            | 0.00            | 0.00            | QC21                   |                         |

Part Op 110 - 1- Cut D2244 extrusion to 62.00" long as per Dwg D2310 2- Drill extrusion as per Dwg D2310 using drill Jig DT8230  
Descriptions: 3- OPEN HOLE FOR BUSHING TO SIZE AS PER DWG AND C'SINK. 4- Weld Fwd end cap and bushing as per Dwg D2310 A/R AL ROD Batch: 136158 5- Grind end cap and bottom bushing welds flush 6- Machine top weld on bushing flush as per dwg.

130 - 1-Weld Fwd end cap and bushing as per Dwg D2310 A/R AL ROD Batch: 4130137 2-Grind end cap and bottom bushing welds flush

170 - 1-Rivet as per Dwg D2310 3-Weld Aft end cap as per Dwg D2310 A/R AL ROD Batch: 4130137 4-Grind end cap welds flush

210 - START TIME: 2:45 FINISH TIME: 3:15 O.V.T: 320°

220 - \*\*\*Install Dart labels after wing walk\*\*\*

230 - \*\*\*Install Dart labels after wing walk\*\*\*

255 - Photocopy bluefile & type labels per PPP D350-591-113 CHG005

260 - Identify and pack for shipping as per PPP D350-591-113

Wing walk Batch M138373

### Job Allocations

167073/5001796x4



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>             Skid-tube <input type="checkbox"/><br/>             Machining <input type="checkbox"/><br/>             Thermoforming <input type="checkbox"/><br/>             Large Fab <input type="checkbox"/> </div> <div>             Cross tube <input type="checkbox"/><br/>             Small Fab <input type="checkbox"/><br/>             Finishing <input type="checkbox"/><br/>             Composite <input type="checkbox"/> </div> <div>             Water Jet <input type="checkbox"/><br/>             Prod. Eng. Coord. <input type="checkbox"/><br/>             Rec/Store/Packaging <input type="checkbox"/><br/>             Supplier <input type="checkbox"/> </div> <div>             Engineering <input type="checkbox"/><br/>             Quality <input type="checkbox"/><br/>             Other <input type="checkbox"/> </div> </div> |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |
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| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Completed By                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |
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| <div style="display: flex; flex-direction: column;"> <div>Environment <input type="checkbox"/></div> <div>Design <input type="checkbox"/></div> <div>Doc/Data <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Pre <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Internal Transport <input type="checkbox"/></div> <div>Tribal Knowledge <input type="checkbox"/></div> <div>LOA <input type="checkbox"/></div> <div>Substation <input type="checkbox"/></div> <div>Past Expiry Date <input type="checkbox"/></div> <div>Misidentified <input type="checkbox"/></div> </div> | <div style="display: flex; flex-direction: column;"> <div><input type="checkbox"/> No Re-verification</div> <div><input type="checkbox"/> Operator</div> <div><input type="checkbox"/> Offset/Setup</div> <div><input type="checkbox"/> Supplier</div> <div><input type="checkbox"/> Training</div> <div><input type="checkbox"/> Use for Testing</div> <div><input type="checkbox"/> Poor Information</div> <div><input type="checkbox"/> Rushing</div> <div><input type="checkbox"/> Product Improvement</div> <div><input type="checkbox"/> Process Improvement</div> <div><input type="checkbox"/> Manufacturing Process</div> <div><input type="checkbox"/> Past Due</div> </div> | <div style="display: flex; flex-direction: column;"> <div><input type="checkbox"/> Pressure/Forced</div> <div><input type="checkbox"/> Bending</div> <div><input type="checkbox"/> Centre Not Concentric</div> <div><input type="checkbox"/> Cracks</div> <div><input type="checkbox"/> Crimp/Kink/Ripple/Wave</div> <div><input type="checkbox"/> Cuffs</div> <div><input type="checkbox"/> Crushing</div> <div><input type="checkbox"/> Heat Treat</div> <div><input type="checkbox"/> Wave/Twist in Tube</div> <div><input type="checkbox"/> Marks/Chatter</div> </div>                                                                                                                                                                                                                                                                                                                                                                                                 | <div style="display: flex; flex-direction: column;"> <div><input type="checkbox"/> Temperature/Cure</div> <div><input type="checkbox"/> Set-up</div> <div><input type="checkbox"/> BOM/Route</div> <div><input type="checkbox"/> Broken/Damage/Defect</div> <div><input type="checkbox"/> Inspection Incomplete/Unqualified</div> <div><input type="checkbox"/> Contamination</div> <div><input type="checkbox"/> Countersink</div> <div><input type="checkbox"/> Cut Too Short</div> <div><input type="checkbox"/> Instructions Incomplete/Unclear</div> <div><input type="checkbox"/> Drill Holes</div> </div> | <div style="display: flex; flex-direction: column;"> <div><input type="checkbox"/> Power Loss/Surge</div> <div><input type="checkbox"/> Folio/Program</div> <div><input type="checkbox"/> Grain</div> <div><input type="checkbox"/> Weld</div> <div><input type="checkbox"/> Wrong Stock Pulled</div> <div><input type="checkbox"/> Out of Sequence</div> <div><input type="checkbox"/> Off-set</div> <div><input type="checkbox"/> Mislabelled</div> <div><input type="checkbox"/> Fit/Function</div> <div><input type="checkbox"/> Misaligned/off center</div> </div> | <div style="display: flex; flex-direction: column;"> <div><input type="checkbox"/> Positioned Wrong</div> <div><input type="checkbox"/> Outside Dimensions</div> <div><input type="checkbox"/> Over/Under tolerance</div> <div><input type="checkbox"/> Part Incorrect</div> <div><input type="checkbox"/> Part Lost/Missing</div> <div><input type="checkbox"/> Part Moved</div> <div><input type="checkbox"/> Drawing</div> <div><input type="checkbox"/> Finish</div> <div><input type="checkbox"/> Misread</div> <div><input type="checkbox"/> Turning Sequence</div> </div> |
| OTHER : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |

| Operation             | Component Part | Required | Inventory | Allocated | Std Qty |
|-----------------------|----------------|----------|-----------|-----------|---------|
| 90-Start up Operation | D2244-116      | 4        | 35        | 0         | 0       |
| 130-Large Fab         | D2275          | 4        | 4         | 0         | 0       |
|                       | D2673-34       | 8        | 32        | 0         | 0       |
| 170-Large Fab         | D2582          | 4        | 10        | 0         | 0       |
|                       | MS20600-AD4W3  | 64       | 399       | 0         | 0       |
| 240-Packaging         | K591-113       | 4        | 0         | 0         | 0       |

S006434  
 S000552  
 ✓ S009472

### Part Specifications

Specifications could not be found.

Plex 10/24/17 10:05 AM dart.lacelle.linda

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/>                                                                                                                                                                                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube <input type="checkbox"/></td> <td style="width:12.5%;">Cross tube <input type="checkbox"/></td> <td style="width:12.5%;">Water Jet <input type="checkbox"/></td> <td style="width:12.5%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  |                       |                                              |  | Skid-tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                          | Cross tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                               | Water Jet <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                     | Engineering <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                              | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     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| <b>Root Cause</b><br><table style="width:100%; border: none;"> <tr> <td style="width:50%;">           Environment <input type="checkbox"/><br/>           Design <input type="checkbox"/><br/>           Doc/Data <input type="checkbox"/><br/>           Equip/Tooling <input type="checkbox"/><br/>           Handling/Pre <input type="checkbox"/><br/>           Material <input type="checkbox"/><br/>           Internal Transport <input type="checkbox"/><br/>           Tribal Knowledge <input type="checkbox"/><br/>           LOA <input type="checkbox"/><br/>           Substation <input type="checkbox"/><br/>           Past Expiry Date <input type="checkbox"/><br/>           Misidentified <input type="checkbox"/> </td> <td style="width:50%;">           No Re-verification <input type="checkbox"/><br/>           Operator <input type="checkbox"/><br/>           Offset/Setup <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Training <input type="checkbox"/><br/>           Use for Testing <input type="checkbox"/><br/>           Poor Information <input type="checkbox"/><br/>           Rushing <input type="checkbox"/><br/>           Product Improvement <input type="checkbox"/><br/>           Process Improvement <input type="checkbox"/><br/>           Manufacturing Process <input type="checkbox"/><br/>           Past Due <input type="checkbox"/> </td> </tr> </table> |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Environment <input type="checkbox"/><br>Design <input type="checkbox"/><br>Doc/Data <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Pre <input type="checkbox"/><br>Material <input type="checkbox"/><br>Internal Transport <input type="checkbox"/><br>Tribal Knowledge <input type="checkbox"/><br>LOA <input type="checkbox"/><br>Substation <input type="checkbox"/><br>Past Expiry Date <input type="checkbox"/><br>Misidentified <input type="checkbox"/> | No Re-verification <input type="checkbox"/><br>Operator <input type="checkbox"/><br>Offset/Setup <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Training <input type="checkbox"/><br>Use for Testing <input type="checkbox"/><br>Poor Information <input type="checkbox"/><br>Rushing <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Past Due <input type="checkbox"/> | <b>FAULT CATEGORY</b><br><table style="width:100%; border: none;"> <tr> <td style="width:33%;">           Pressure/Forced <input type="checkbox"/><br/>           Bending <input type="checkbox"/><br/>           Centre Not Concentric <input type="checkbox"/><br/>           Cracks <input type="checkbox"/><br/>           Crimp/Kink/Ripple/Wave <input type="checkbox"/><br/>           Cuffs <input type="checkbox"/><br/>           Crushing <input type="checkbox"/><br/>           Heat Treat <input type="checkbox"/><br/>           Wave/Twist in Tube <input type="checkbox"/><br/>           Marks/Chatter <input type="checkbox"/> </td> <td style="width:33%;">           Temperature/Cure <input type="checkbox"/><br/>           Set-up <input type="checkbox"/><br/>           BOM/Route <input type="checkbox"/><br/>           Broken/Damage/Defect <input type="checkbox"/><br/>           Inspection Incomplete/Unqualified <input type="checkbox"/><br/>           Contamination <input type="checkbox"/><br/>           Countersink <input type="checkbox"/><br/>           Cut Too Short <input type="checkbox"/><br/>           Instructions Incomplete/Unclear <input type="checkbox"/><br/>           Drill Holes <input type="checkbox"/> </td> <td style="width:33%;">           Power Loss/Surge <input type="checkbox"/><br/>           Folio/Program <input type="checkbox"/><br/>           Grain <input type="checkbox"/><br/>           Weld <input type="checkbox"/><br/>           Wrong Stock Pulled <input type="checkbox"/><br/>           Out of Sequence <input type="checkbox"/><br/>           Off-set <input type="checkbox"/><br/>           Misabeled <input type="checkbox"/><br/>           Fit/Function <input type="checkbox"/><br/>           Misaligned/off center <input type="checkbox"/> </td> <td style="width:33%;">           Positioned Wrong <input type="checkbox"/><br/>           Outside Dimensions <input type="checkbox"/><br/>           Over/Under tolerance <input type="checkbox"/><br/>           Part Incorrect <input type="checkbox"/><br/>           Part Lost/Missing <input type="checkbox"/><br/>           Part Moved <input type="checkbox"/><br/>           Drawing <input type="checkbox"/><br/>           Finish <input type="checkbox"/><br/>           Misread <input type="checkbox"/><br/>           Turning Sequence <input type="checkbox"/> </td> </tr> </table> |  |  |                       |                                              |  | Pressure/Forced <input type="checkbox"/><br>Bending <input type="checkbox"/><br>Centre Not Concentric <input type="checkbox"/><br>Cracks <input type="checkbox"/><br>Crimp/Kink/Ripple/Wave <input type="checkbox"/><br>Cuffs <input type="checkbox"/><br>Crushing <input type="checkbox"/><br>Heat Treat <input type="checkbox"/><br>Wave/Twist in Tube <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/> | Temperature/Cure <input type="checkbox"/><br>Set-up <input type="checkbox"/><br>BOM/Route <input type="checkbox"/><br>Broken/Damage/Defect <input type="checkbox"/><br>Inspection Incomplete/Unqualified <input type="checkbox"/><br>Contamination <input type="checkbox"/><br>Countersink <input type="checkbox"/><br>Cut Too Short <input type="checkbox"/><br>Instructions Incomplete/Unclear <input type="checkbox"/><br>Drill Holes <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/><br>Folio/Program <input type="checkbox"/><br>Grain <input type="checkbox"/><br>Weld <input type="checkbox"/><br>Wrong Stock Pulled <input type="checkbox"/><br>Out of Sequence <input type="checkbox"/><br>Off-set <input type="checkbox"/><br>Misabeled <input type="checkbox"/><br>Fit/Function <input type="checkbox"/><br>Misaligned/off center <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/><br>Outside Dimensions <input type="checkbox"/><br>Over/Under tolerance <input type="checkbox"/><br>Part Incorrect <input type="checkbox"/><br>Part Lost/Missing <input type="checkbox"/><br>Part Moved <input type="checkbox"/><br>Drawing <input type="checkbox"/><br>Finish <input type="checkbox"/><br>Misread <input type="checkbox"/><br>Turning Sequence <input type="checkbox"/> |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
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Dart Hawkesbury  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D350-591-113**  
**Job Sheet 166557**



Part No: D350-591-113

Job Qty: 4 ea

Part Name: Heli-Access Step, Short, High Gear



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/11/17

Job Tracking No:

Due Date: 10/27/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Customer: Airbus Helicopters - Marignane (CEURO24)

Aeroport International De Marseille Cedex Marignane Marseille, , 13725 France ph:+33 4 42 85 85 85 fx:+33 4 42 85 83 00.

Note: DWG DSI 9525 REV A, D2310 REV D IPP Rev:H 04.11.09 Reformat KJ/JLM IPP Rev:E as per ECN10-586  
10.06.18 DD verf:EC

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Due Date | Standard  |         | Workcenter/Supplier   |           |
|-------|--------------------|-------|----------|-----------|---------|-----------------------|-----------|
|       |                    |       |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |
| 90    | Start up Operation | 4 Ea  | 10/26/17 | 0.00      | 0.00    | Start up container    |           |
| 100   | DC                 | 4 pcs | 10/26/17 | 0.00      | 0.00    | DC                    |           |
| 110   | Large Fab          | 4 pcs | 10/26/17 | 0.00      | 4.13    | Large Fab 8           |           |
| 120   | QC                 | 4 pcs | 10/26/17 | 0.00      | 0.00    | QC5                   |           |
| 123   | Mill Conv          | 4 pcs | 10/26/17 | 0.00      | 0.83    | Mill Conv 1           |           |
| 126   | QC                 | 4 pcs | 10/26/17 | 0.00      | 0.00    | QC5                   |           |
| 130   | Large Fab          | 4 pcs | 10/26/17 | 0.00      | 4.13    | Large Fab 2           |           |
| 132   | Mill Conv          | 4 pcs | 10/26/17 | 0.00      | 0.83    | Mill Conv 1           |           |
| 140   | QC                 | 4 pcs | 10/26/17 | 0.00      | 0.00    | QC9                   |           |
| 150   | QC                 | 4 pcs | 10/26/17 | 0.00      | 0.00    | QC5                   |           |
| 160   | HandFinish         | 4 pcs | 10/26/17 | 0.00      | 0.89    | HandFinish1           |           |
| 170   | Large Fab          | 4 pcs | 10/26/17 | 0.00      | 4.13    | Large Fab 2           |           |
| 180   | QC                 | 4 pcs | 10/26/17 | 0.00      | 0.00    | QC10                  |           |
| 190   | QC                 | 4 pcs | 10/26/17 | 0.00      | 0.00    | QC5                   |           |
| 200   | HandFinish         | 4 pcs | 10/26/17 | 0.00      | 0.89    | HandFinish1           |           |
| 210   | Powdercoat         | 4 pcs | 10/26/17 | 0.00      | 0.82    | Powdercoat1           |           |
| 220   | HandFinish         | 4 pcs | 10/27/17 | 0.00      | 0.89    | HandFinish3           |           |
| 230   | QC                 | 4 pcs | 10/27/17 | 0.00      | 0.00    | QC3                   |           |
| 240   | Packaging          | 4 pcs | 10/27/17 | 0.00      | 0.00    | Packaging1            |           |
| 250   | QC                 | 4 pcs | 10/27/17 | 0.00      | 0.00    | QC4                   |           |
| 260   | Packaging          | 4 pcs | 10/27/17 | 0.00      | 0.00    | Packaging3            |           |
| 270   | QC21-FG            | 4 Ea  | 10/27/17 | 0.00      | 0.00    | QC21                  |           |

Part Op 100 - Photocopy bluefile & type labels per PPP D350-591-113 CHG005

Descriptions: 110 - 1-Cut D2244 extrusion to 62.00" long as per Dwg D2310 2-Drill extrusion as per Dwg D2310 using drill Jig DT8230

123 - OPEN HOLE FOR BUSHING TO SIZE AS PER DWG AND C'SINK.

130 - 1-Weld Fwd end cap and bushing as per Dwg D2310 A/R AL ROD Batch: \_\_\_\_\_ 2-Grind end cap and bottom bushing welds flush

132 - Machine top weld on bushing flush as per dwg.

170 - 1-Rivet as per Dwg D2310 3-Weld Aft end cap as per Dwg D2310 A/R AL ROD Batch: \_\_\_\_\_

4-Grind end cap welds flush

210 - START TIME: \_\_\_\_\_ FINISH TIME: \_\_\_\_\_

- 220 - \*\*\*Install Dart labels after wing walk\*\*\*  
 230 - \*\*\*Install Dart labels after wing walk\*\*\*  
 260 - Identify and pack for shipping as per PPP D350-591-113

| Job Allocations |                |          |           |           |         |
|-----------------|----------------|----------|-----------|-----------|---------|
| Operation       | Component Part | Required | Inventory | Allocated | Std Qty |
| 110-Large Fab   | D2244-116      | 4        | 41        | 0         | 0       |
| 130-Large Fab   | D2275          | 4        | 4         | 0         | 0       |
|                 | D2673-34       | 8        | 40        | 0         | 0       |
| 170-Large Fab   | D2582          | 4        | 10        | 0         | 0       |
|                 | MS20600-AD4W3  | 64       | 99        | 0         | 0       |
| 240-Packaging   | K591-113       | 4        | 0         | 0         | 0       |

#### Part Specifications

Specifications could not be found.

Plex 10/11/17 11:22 AM Dart.lajeunesse.marie

**DART**  
 AEROSPACE  
**S001237**



Heli - Access Step, Short, High Gear

**PART NO: D350 - 591 - 113**

**Revision:**

**Operation:**

**Quantity:**

**Change No:**

**Start up Operation**

**0**

**Mfg Date: 10/23/17**

**Job No: 166557**

**Dart Aerospace Ltd.**

1270 Aberdeen Street  
 Hanover, ON K64 1K7  
 CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

**DART**  
AEROSPACE  
**S001796**

**Dart Aerospace Ltd.**

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Email: sales@dartaero.com  
www.dartaerospace.com



**Heli – Access Step, Short, High Gear**

**PART NO: D350 – 591 – 113**  
**Revision:**  
**Operation: Packaging**  
**Change No:**

**Mfg Date: 10/24/17**

**Job No: 167073**